

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013564**Date Inspected:** 22-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. OBG Field Splice 2E/3E Face C2 Repairs (Outside)
2. OBG Field Splice 3E/4E Face B1 (Inside)
3. OBG Field Splice 3E/4E Face E1 and E2 (Outside)
4. OBG Field Splice 3E/4E Face F1 (Inside)

Field Splice 2E/3E Face C2 (Outside)

The QA inspector periodically observed ABF welding personnel Rick Clayborn and a helper performing excavations for rejectable indications discovered by ultrasonic testing (UT) utilizing mechanical grinding. QC inspector Bernard Docena was noted to be present in order to monitor the progression and ensure the work is within contract specifications. At this time the welder is in the process of performing the excavation at Y location designated 3370mm. The QC inspector presented the welding repair report to the QA inspector for basic review and the work progressed. The repair cavity was prepared in accordance with the procedure noted as ABF-WPS-D1. 5-1000 Repair and was cleaned to bright metal. QC inspector Jim Cunningham was observed performing magnetic particle testing on the repair excavations presented with no rejectable indications noted at the time of review. The welder proceeded to another repair area prior to welding the initial excavation and relayed to the QA inspector he would excavate several areas prior to making the repairs. The work progressed throughout the QA inspector shift, was not completed and appeared to be in general conformance with the contract documents.

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Field Splice 3E/4E Face B1 (Inside)

The QA inspector noted ABF welding personnel James Zhen performing shielded metal arc welding (SMAW) and grinding/blending operations at the weld designated B1. The welder is in the process of performing this work for areas identified previously by the QC department for minor welding/blending. QC inspector Bonafacio Daquinag was noted to be present in order to monitor the progress and adherence to the contract documents and the established WPS. The work progressed throughout the balance of the QA inspector's shift and appeared to be progressing in general conformance with the contract documents.

Field Splice 3E/4E Face F1 (Inside)

The QA inspector noted ABF welding personnel Chun Fai Tsui performing grinding/blending operations at the deck plate/edge plate transition in which additional weld metal is being added for transitioning smoothly at the interface. This work is progressing in response to request for information (RFI) designated 2097 Rev 0. QC inspector Tony Sherwood was noted to be present in order to monitor the progress and adherence to the contract documents and the established WPS. The work progressed throughout the balance of the QA inspector's shift and appeared to be progressing in general conformance with the contract documents.

Field Splice 3E/4E Face E (Second side-Outside)

The QA inspector noted and periodically observed ABF welding operators Rory Hogan and Jeremy Dolan performing the backgouging and grinding operations for face E on the second side (Outside). The welding operators continued setting the equipment up and periodically performing the operation throughout the shift. The work was not completed on this date or turned over to QC for verification at this time but appeared to be progressing in general conformance with the contract documents.



Summary of Conversations:

The QA inspector was presented several requests for welding repairs at 1415 by WQCM Jim Bowers which were identified as number 18, 19 and 20. This information was relayed to lead QA inspector Bill Levell in which Mr. Level informed the QA inspector at 1420 the contractor was given verbal approval to proceed with the repairs with formal approval to follow. This information was relayed to Mr. Bowers via phone by Mr. Levell. At 1445 the QA inspector received two additional requests for repair designated as 21 and 22 from the WQCM and this information was relayed to Mr. Levell in which verbal approval to proceed was granted at 1450 with Mr. Levell relaying the approval to the WQCM via phone.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)813-3677, who represents the Office of Structural Materials for your project.

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| Inspected By: | Foerder,Mike | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
